Work Order ID 57656

April 13, 2010 7:21;36 AM

Item ID: D3681-1





Page 1

April 13, 2010	7.21,30 AW		<u> </u>									
Item ID:	D3681-1	\		Accept				 :	Setup	Start		
Revision ID:										Stop		
Item Name:	Spacer			1011 SOII 1001						этор		
Start Date:	4/13/10	Start Qty: 40.00			Cust Item	ID:						
Required Date	e: 4/15/10	Req'd Qty: 40.00			Customer	;						
Reference:			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						_	G	1 1 0016106 0	
Approvals:	Process P	lan:	Date:	Tooling:	I	Date:		j	Run	Start		
	QC:		Date:	SPC (Y/N):		Date:				Stop		
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr										
D3681	Re	ev A										
100				0.00								
		Hardinge CNC LATHE S	SMALL									
Hardinge		Memo		0.00								
Hardinge CNC La	athe Small	I-TURN AS REV:	PER FOLIO FA71 □2-DEBURR	1& DWG D3681□FOLIO REV: AS REQUIRED	ДД □DWG ~	>L	14651	63 (D			
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00								•
					•	L 10	11.	2				
QC	•	Memo		0.00	ک	L 10	16516	3			***	
Quality Control												
						7						
120	_	QC8- Inspect parts - seco	and check	0.00	of.	10.5-	3	./ -				
					(40				
QC		Memo		0.00								
Quality Control												

Dart A	erospace	Ltd
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W/O:		, , , , , , , , , , , , , , , , , , , ,	V	ORK ORDER	CHANGES					
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ/	\:	Date:	
	R	esolution:	Disposit	ion:	QA	: N/C Cld	sed:		Date:	
NCR:		,	WORK OR	DER NON-CO	FORMANCI	E (NCR)			
DATE	STEP	Description of NC		Corrective Action		1 0: 0	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action De	scription Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
										-
									·	
•				·						

April 13, 2010 7:21:37 AM

Required Date: 4/15/10

Item ID:

D3681-1

Setup Start

Stop





Item Name: Start Date:

Revision ID:

Spacer 4/13/10

Start Oty: 40.00

Reg'd Otv: 40.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Accept

Date:

Start

Stop



Date: _____

SPC (Y/N):

Date:

Draw

Rev.

Reject

Insp.

Sequence ID/ Work Center ID

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ Run Hours

0.00

Draw

Number

Code

Plan

Accept Oty **Qty**

Run

Reject Number

Stamp

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/05/04 Af

Dart	Aer	ospa	ce	Ltd
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W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	PROCEDURE CHANGE By Date					Qty	Approval QC Inspector	
Part No	:	PAR #:	Fault Cate	egory:	NCF	R: Yes	No DQA	\ :	_ Date: _	
	R	esolution:	Disposition	on:	QA:	N/C CI	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)		.,,	·
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	ction B	Sign &	Verific		Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
									ا	
		·								

Picklist Print

April 13, 2010 7:21:36 AM

Work Order ID: 57656

Parent Item:

D3681-1

Parent Item Name:

Spacer

Comments:

IPP □ Rev A new issue 07-10-30 DD verified by:

IPP Rev:B Ecn 1056 Rev A dwg DD

Start Date: 4/13/10

Required Date: 4/15/10

Start Oty: 40.00

Required Oty: 40.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch Purchased

Bin Primary Item Location

No

Last Location

Route Seq ID 100

Unit of Oty on Measure Hand

0.0000

Remaining Otv Qty To Pick Issued 14.3158

Date Issued

Status

M6061T6T0.3125W.05



ALUM TUBE .3125 x .058w

14.5 DL 10/05/03

Dart Aerospace	Ltd
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W/O:			V	VORK ORDER CHANGI	ES			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·						
D								
Part No		PAR #:						
	H.	esolution:					Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC	Initial	Corrective Action Section	n B Sign &	Verification		Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
								-
								!
		,						
				·				

DART AEROSPACE LTD :	Work Order: 57656
Description: Snacer	Part Number: D3651-
Inspection Dwg: \(\frac{1}{2}\langle_0 \times \) Rev: \(\frac{1}{2}\langle_0 \times \)	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	:le	_ Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
-313	±.010	-313	1			
.197	+.010	-199				·
.025X45°	+ 030 + 030 + 030	025/80				
4.080	+-030	4.097				
-						
·				-		

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10/05/03	Date: 10 ' 5 - 3	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

4.695

D SEE DETAIL A Ø 0.313 (STOCK, REF) Ø 0.197 (STOCK, REF) 4.080+0.030 С **D3681-1 SPACER** 0.025 X 45° CHAMFER-(TYP) DETAIL A (SCALE 4 : 1) NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-226/8 (REF. DART SPEC. M6061T6T0.313W.058)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs Α NEW ISSUE DC 07.11.08 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE USA, INC. PORT HADLOCK, WA Α DRAWN 30 DRAWING NO. CHECKED REV. A D3681 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE SPACER DE APPR. 2:1 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.

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WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. DATE 07.11.08

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	. PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		• ;									
_										٠.	
Part No:		PAR #:	Fault Category:			NCR: Yes No DQA: Date:					
			Disposition:								
NCR:		W	ORK OR	DER NON-CONFO	ORMANCE	(NCR)	, , , , , , , , , , , , , , , , , , ,				
DATE STEP		Description of NC Section A	Corrective Action Section Initial Action Description Chief Eng Chief Eng			Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector	
	_		Office Eng	. Office Eng		Date		_		-	
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